

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2017-158 Date Opened: 25 September 2017 Title: AssemblyAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Cargo Basket Product Model: Standard Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
JC
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
69810	3	Basket	JC
69827	2	Placard	JC
70405	4	Walkway	JC
84255	2	Handle Installation	JC
84240	0	Lid Prop Installation	JC

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR

Work performed by:

Print: C. Brander/J. Rekve

ICC / Dual Inspection performed by:

Print: J. Clarke

Work Order closed by:

Print: J. Clarke

Approved Manufacturing Facility 73-04

Sign: [Signature]Sign: [Signature]Sign: [Signature]

Form 20.D.03

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

SCA: AD01Date: 26-Sep-17SCA: AD02Date: 26-Sep-17SCA: AD02Date: 27-Sep-17

Rev. Original 23 Sep 2014



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY (2064/407 STD) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 69811-01 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-93

Remaining Tasks to be Performed: NONE

Signature: Jff chh.

Date: 03 APR 2017 Lic. No. / SCA AD02

Serviceable



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: LID (MED) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 69812-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-49

Remaining Tasks to be Performed: ASSEMBLY w/ BODY

Signature: JH CRL

Date: 04 MAY 2017 Lic. No. / SCA AD02

Serviceable



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Medium basket handle No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 84261-01 Serial No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-31

Remaining Tasks to be Performed: Instal

Signature: Daniel Mart

Date: Feb 23/2017 Lic. No. / SCA AD-05

Serviceable

## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC

V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: MS20001P4-9600

Aircraft: Multiple Model: Multiple

Description: Hinge

Supplier: Bisco

Color: N/A

WO#: N/A

PO# 16030



1. Lid Assembly

a. Install lid bumpers on bottom.

- i. Drill ¼" holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

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b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

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c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
  1. 0.25" from edge of tread plate, centre on cross members (0.38")
  2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using ¼" piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

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d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
  1. 90610 (Robinson R44) basket only:
    - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
    - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).

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- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
  - i. Locate sheet on basket.
  - ii. Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
  - iii. Remove sheet and de-burr holes in sheet and rim.
  - iv. Apply bead of RTV silicone sealant along all tubes under sheet.
  - v. Locate sheet on basket, and cleco in place.
  - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
  - i. Locate sheet on basket. Ensure sufficient clamps are in place.
  - ii. Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
  - iii. Remove sheet and de-burr holes in sheet and rim.
  - iv. Apply bead of Pro-Seal sealant along all tubes under sheet.
  - v. Locate sheet on basket, and cleco in place.
  - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

### 3. Hinge Installation

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 766, 784 – 90"
    - 5. 940, 946, 959 – 95"
    - 6. 1006 – 107"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations

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73-04  
01



c. Install lid on basket

- i. Locate lid on hinge (all baskets)
  1. center fore/aft
  2. 0.15" – 0.18" down from top edge
- ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
- iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
- iv. Remove hinge and de-burr holes in hinge and lid rim.
- v. Cleco lid to hinge with 5/32 clecos.
- vi. Install hinge with CherryMax rivets
  1. CR3523-5-02 monel rivets – last 2 rivets in each end
  2. CR3213-5-02 aluminum rivets – all other locations

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73-04  
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d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to 20-25 in-lbs.

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73-04  
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b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to 20-25 in-lbs.

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c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

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d. Record PO/WO of all parts used in steps above on attached material tracking list.

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5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket. <sup>PO</sup> it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt. <sup>73-04 01</sup> CMB
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

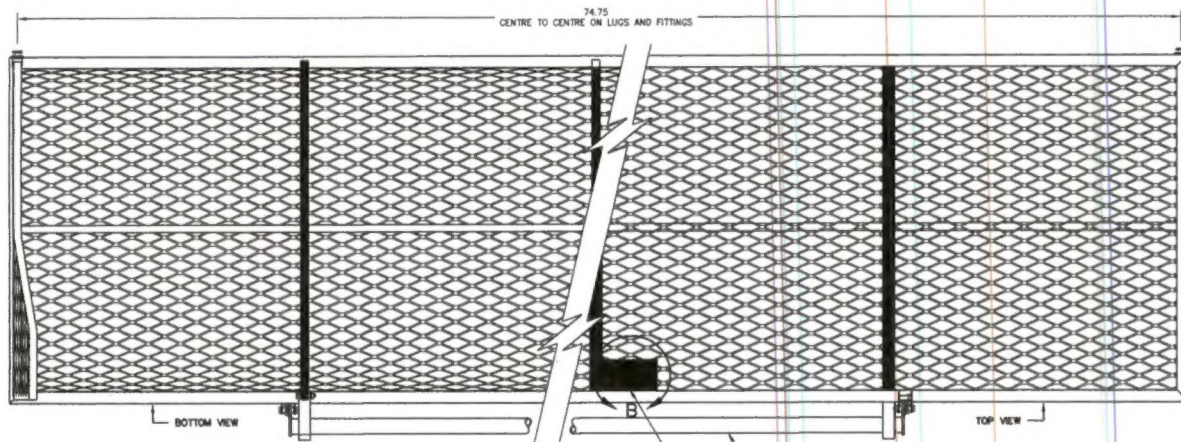
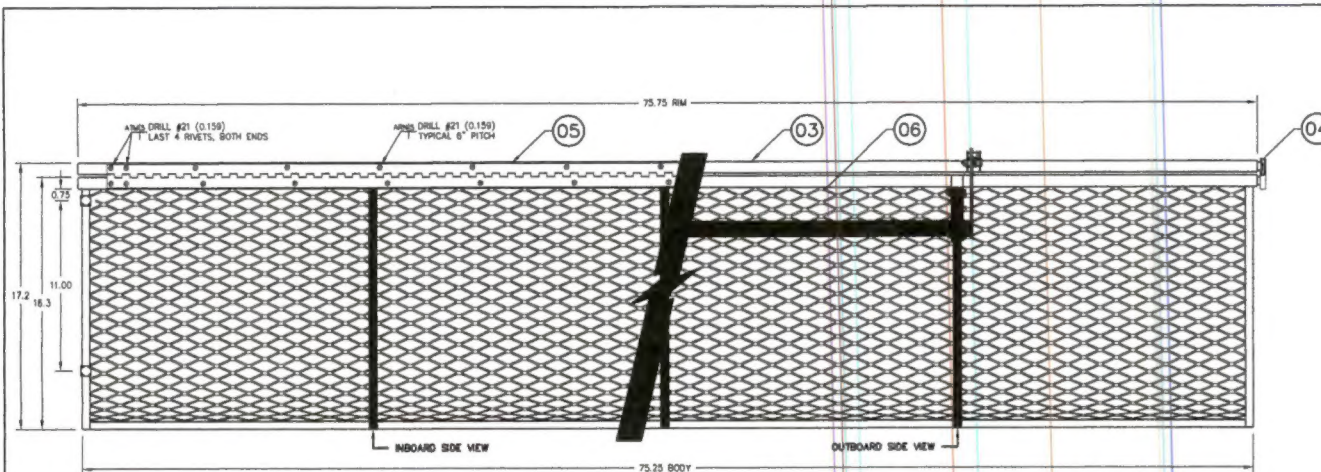
N/A

7. Final Inspection

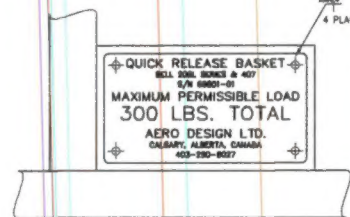
Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

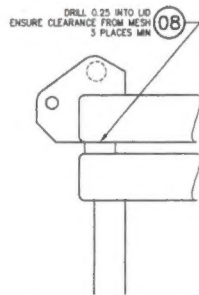
AD  
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02



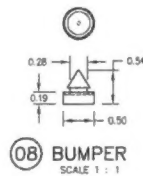
01 CARGO BASKET ASSEMBLY



DETAIL B  
SCALE 1 : 1  
LOOKING AT PLACARD BRACKET



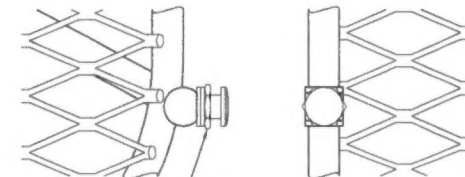
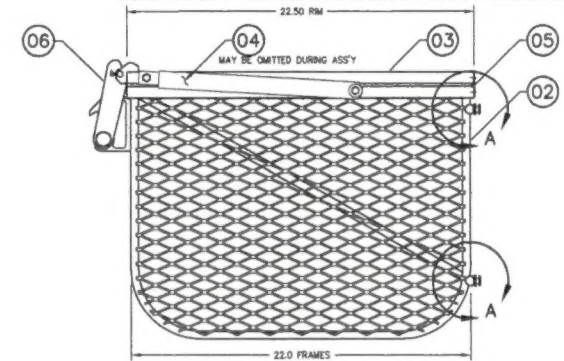
SCALE 1 : 1



SCALE 1 : 1

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED LUGS	BJC	08/11/2008
2	PLACARD CHANGED, AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	28/06/2009
3	HINGE RIVETS CHANGED, HANDLE DETAILS CHANGED, PLACARD CHANGED	BJC	14/10/2011



DETAIL A

SCALE 1 : 1  
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR  
TYPICAL FRONT AND REAR

NOTE:

1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	AN860-816	WASHER				
4	40088-14	FITTING				
4	CR3213-4-02	CHERRY RIVET				
8	CR3523-5-02	CHERRY RIVET				
4	CR3213-5-02	CHERRY RIVET				
1	49205-14	08 BUMPER				
1	69827-01	07 PLACARD				
1	84255-01	06 HANDLE BAR INSTALLATION				
1	MS20001P4	05 PIANO HINGE				6 FEET LONG
1	36280-01	04 BRACE ASSEMBLY				
1	69812-01	03 LUG ASSEMBLY				
1	69811-01	02 BASKET BODY ASSEMBLY				
1	69810-01	01 CARGO BASKET ASSEMBLY				

BASIC CODE		DASH NO. FOR DIAMETER		APPROVALS		DATE	
REF: HAS 323		N=MFD. HEAD NEAR SIDE		DRAWN: JEFF CLARKE		11 APR 2006	
C=COUNTERSUNK		F=MFD. HEAD FAR SIDE		CHECKED: E. BURGON			
D=DIMPLE		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED			
DIGIT# OF SHEETS		TO BE DIMPLED		DIMENSIONS ARE IN INCHES.			
				TOLERANCES ON:			
				DECIMALS ANGLES			
				X.XXX ±0.010 ±1/2"			
				X.XX ±0.03			
				X.X ±0.1			
				INSTALL NEW RIVET			
				REMOVE/REPLACE RIVET			
				EXISTING RIVET			
				AERO DESIGN LTD.			
				CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAB 290M			
				2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2B 6E7			
				Tel: (403) 292-8827 Fax: (403) 292-8828 aerodesign@shaw.ca			
				BELL 206L, 407			
				QUICK RELEASE CARGO BASKET			
				CARGO BASKET ASSEMBLY			
				SCALE 1 : 4			
				SHEET 1 OF 1			
				A1 69810 3			



# NOTICE

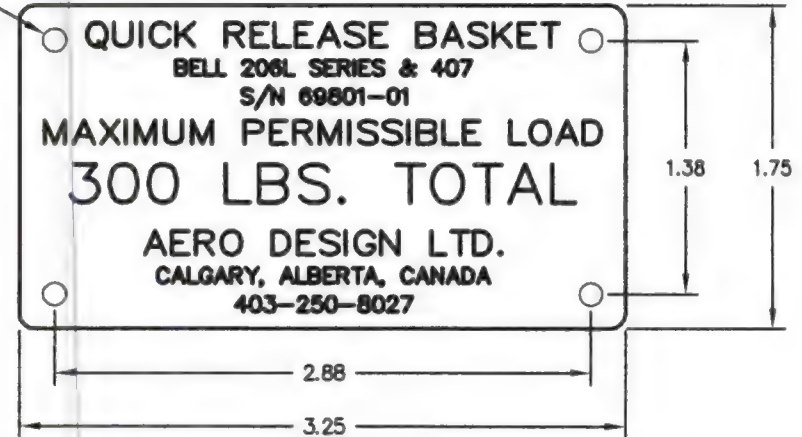
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED TO ENGRAVED ALUMINUM	BJC	19 JUNE 2007
2	INCREASED LOAD	BJC	26 OCT 2011

## NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
 "QUICK RELEASE BASKET" - 0.125 HIGH  
 "BELL 206L SERIES & 407" - 0.080 HIGH  
 "S/N 69801-XX" - 0.080 HIGH  
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
 "300 LBS. TOTAL" - 0.200 HIGH  
 "AERO DESIGN LTD." - 0.125 HIGH  
 "CALGARY, ALBERTA, CANADA" - 0.080 HIGH  
 "403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES

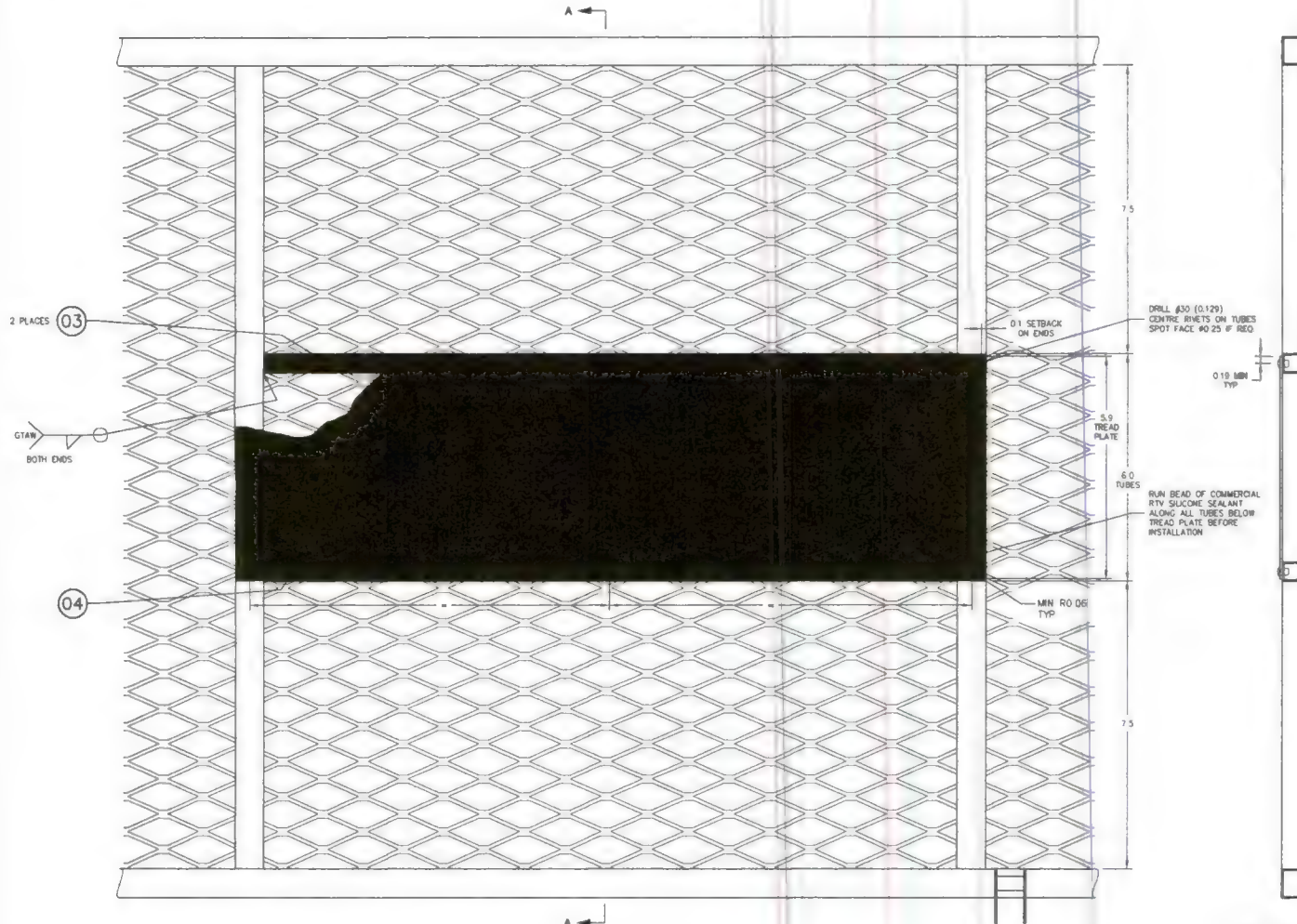


01 PLACARD

1	69827-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net	
			DRAWN: JEFF CLARKE	24 APR 2006		
			CHECKED: E. BURGAIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206L SERIES AND 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1		DWG. SIZE	DWG. NO.
			SHEET 1 OF 1		A4	69827
					REV.	2



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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS; CHANGE TUBES	BUC	MAR 19/08
2	ADD EUROCOPTER EC135; MCDONNELL DOUGLAS MD500; BELL 206B BASKETS	BUC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BUC	MAR 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT RIVET; ADD NOTE 7	BUC	28/05/2014



01 BASKET LID ASSEMBLY

SECTION A-A

NOTES

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2885C. WELDING ROD SHALL CONFORM TO EKTOS-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

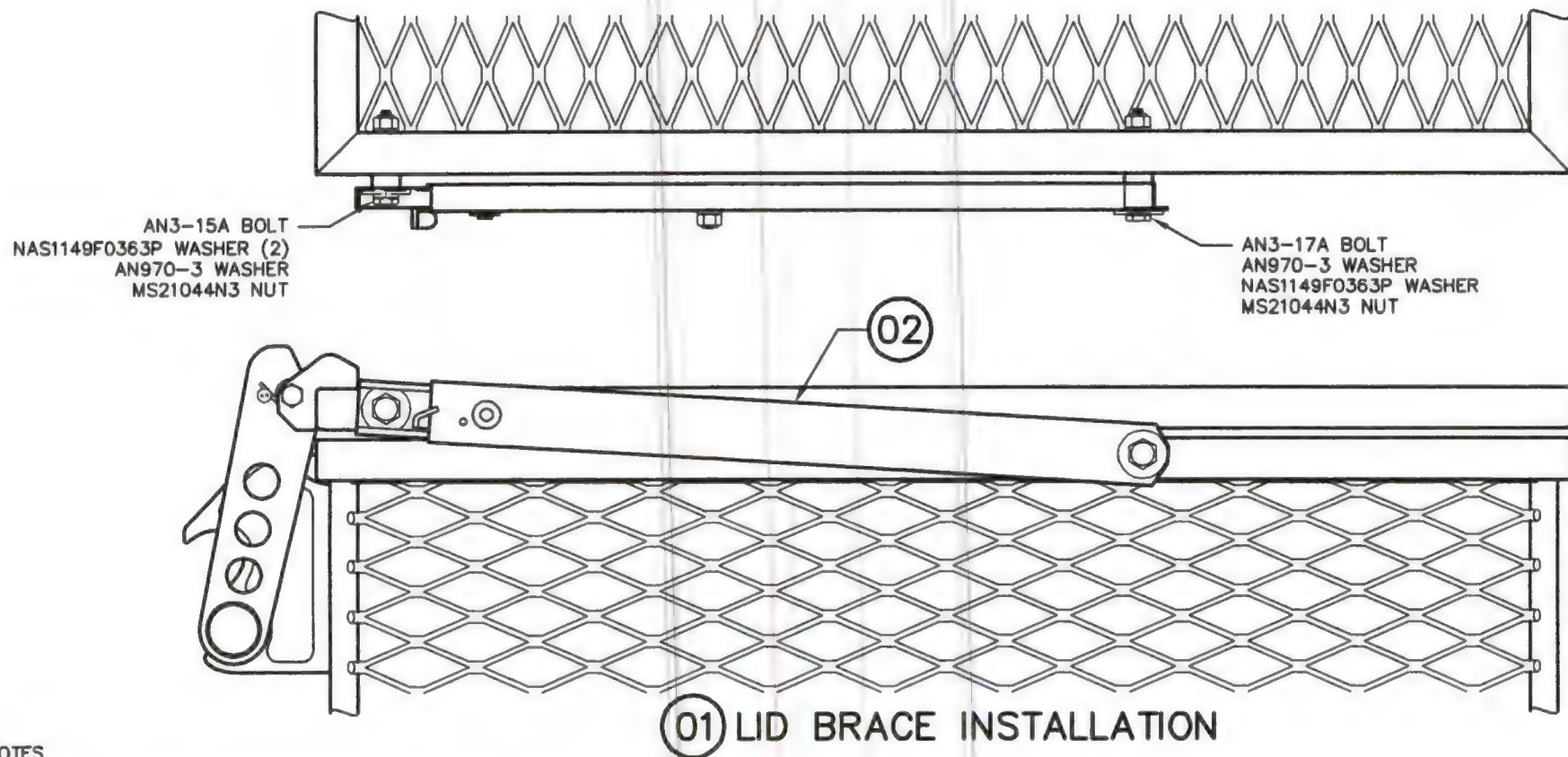
A/R	CR3213-4-02	BLIND RIVET	ALTERNATE	HR3213-4-02
1	70405-04	TREAD PLATE	ALLUMINUM	COMMERCIAL
2	70405-03	03 TUBE	4130 STEEL COND N	MIL-7-6736
1	SEE NOTE 1	02 BASKET LID ASSEMBLY		0.5 X 0.035 WALL TUBE
	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP		
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY				MATERIAL SPEC
				STOCK SIZE

LIST OF MATERIALS

BASIC CODE REF HAS 523		DASH NO FOR DIAMETER N=MED HEAD NEAR SIDE F=MED HEAD FAR SIDE		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGOIN		DATE 21 SEPT 2008	
C=COUNTERSUNK D=DIMPLE DIGIT# OF SHEETS TO BE DIMPLED		DASH NO FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 X.XX ±0.03 X.X ±0.1			
BASIC CODES BJ=MS20470AD BB=MS20426AD AR=CR3213 AR=CR3212		+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		<b>AERO DESIGN LTD.</b> 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604 688-8978 www.aerodesign.ca			
SCALE 1:1.5 SHEET 1 OF 1				CARGO BASKET LID STEP MODIFICATION DWG SIZE: A1 DWG NO: 70405 REV: 4			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



#### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
1	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

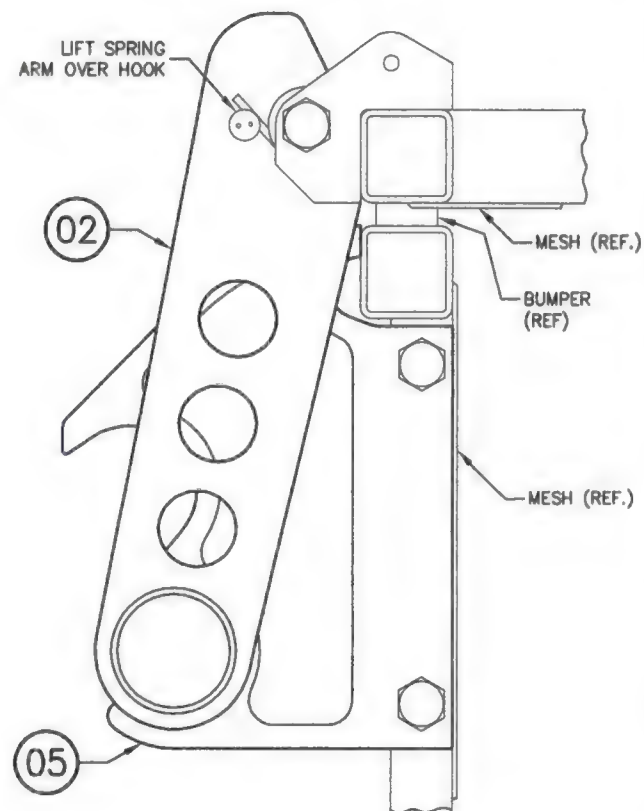
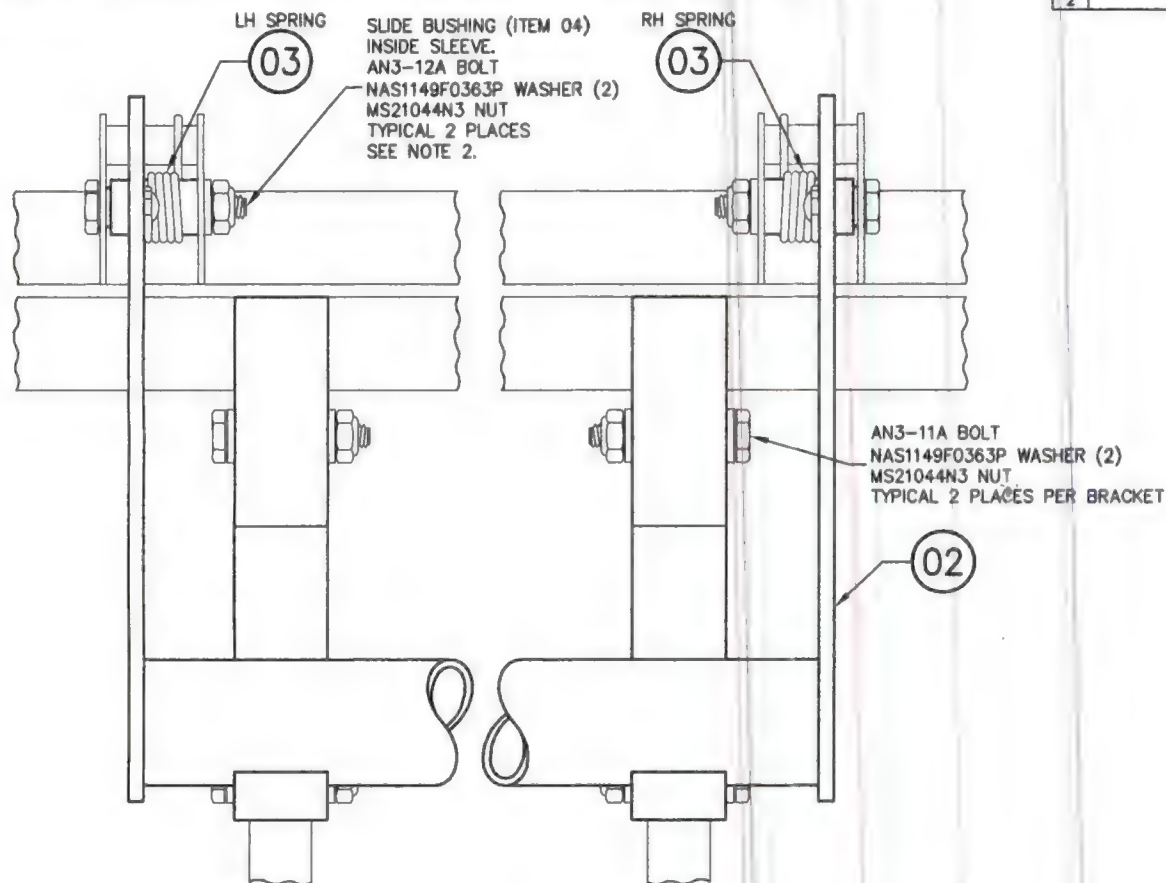
APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.	
TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

		<b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.488.2376 www.aerodesign.ca	
		<b>HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION</b>	
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0



NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
8	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE -- CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGON	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

9688A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G5  
TEL: 804.488.8876 www.aerodesign.ca

**HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2



## CARGO BASKET ASSEMBLY - COMMON

Work Order: \_\_\_\_\_

Date Open: \_\_\_\_\_

### General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

		Basket			Lid Walk	Lid Prop	Handle		
✓	Basket Type	Ass'y	Placard	Mat'l			Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	<a href="#">80210</a>	<a href="#">80227</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Medium	<a href="#">80310</a>	<a href="#">80327</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Long	<a href="#">81110</a>	<a href="#">81127</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell 206L/407 – Right side only									
	Low Standard	<a href="#">69810</a>	<a href="#">69827</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Low Wide	<a href="#">94510</a>	<a href="#">94527</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Low Ski	<a href="#">94610</a>	<a href="#">94627</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	High Ski	<a href="#">76610</a>	<a href="#">76625</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell Medium – left or right									
	Standard	<a href="#">75110</a>	<a href="#">75127</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Extra Large (ski)	<a href="#">95510</a>	<a href="#">95527</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Mega	<a href="#">100610</a>	<a href="#">100627</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell 429 – right or left									
	Standard – Pre S/N 71	<a href="#">95910</a>	<a href="#">95927</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Standard – Post S/N 71	<a href="#">95950</a>	<a href="#">95927</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Eurocopter AS350/AS355 – left or right									
	Short	<a href="#">77610</a>	<a href="#">77627</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Medium	<a href="#">76410</a>	<a href="#">76427</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Long	<a href="#">78410</a>	<a href="#">78427</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Ski	<a href="#">94010</a>	<a href="#">94027</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Robinson R44 – left or right									
	Standard	<a href="#">90610</a>	<a href="#">90627</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
MD600									
	Standard	<a href="#">82810</a>	<a href="#">82827</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).



WO# 2017-158

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0374</b>		
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-158</b>		
6. Item <b>1.</b>	7. Description <b>Cargo Basket</b>	8. Part Number <b>69810-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>69801-91</b>	11. Status/Work <b>New</b>		
12. Remarks <b>Modified with walkway on lid and front end cutout IAW DCL704</b>							
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12          Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>				
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>26 Sep 2017</b>		14d. Name		14e. Date (dd/mm/yyyy)	
<b>Installer Responsibilities</b>							
This certificate does not constitute authority to install.							
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.							
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.							

*HILLSBORO AVIATION*



Work Order: 2017-158

Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

1 of 2

Date Opened: 25 Sept 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		69810-01	<b>Cargo Basket Assembly</b>	sh 69801-91	
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		2017-49
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	See PDS
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		69827-01	Placard	0.063 Sheet, 6061-T6 Aluminum	2015-03
	. . 4		CR3213-4-02	Cherry Rivet		16053
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	17081
	. . A/R		CR3213-4-02	Cherry Rivet		16053
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		69811-01	Basket Body Assembly		2016-93
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	See PDS
	. . 8		NAS1149F0663P	Washer		See PDS
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	16050
	. 8		CR3523-5-02	Cherry Rivet		16063
	. A/R		CR3213-5-02	Cherry Rivet		16053 + 17070
<b>Step 4</b>	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-50
	. . 4		AN3-11A	Bolt		See PDS
	. . 8		NAS1149F0363P	Washer		See PDS
	. . 4		MS21044N3	Nut		See PDS

Work Order: 2017-158

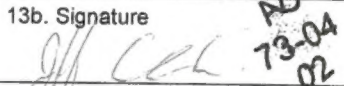
Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

2 of 2

Date Opened: 25 Sept. 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2017-31
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	See PDS
	.. 2		AN3-12A	Bolt		See PDS
	.. 4		NAS1149F0363P	Washer		See PDS
	.. 2		MS21044N3	Nut		See PDS
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2017-119
	. 1		AN3-15A	Bolt		See PDS
	. 1		AN3-17A	Bolt		See PDS
	. 2		AN970-3	Washer		See PDS
	. 3		NAS1149F0363P	Washer		See PDS
	. 2		MS21044N3	Nut		See PDS
Step 6				Inspection	None	



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2018-0053</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>180213-12HX</b>
6. Item <b>1.</b>	7. Description <b>Cargo Basket</b>	8. Part Number <b>69810-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>69801-91</b> <b>WO 2017-158</b>	11. Status/Work <b>New</b>
12. Remarks  This release certificate replaces certificate # 2017-0374 dated 26 Sept 2017 to update for new customer PO in block 5. Certification data: TCCA STC SH00-48, FAA STC SR02253NY Modified with walkway on lid and front end cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>26 Mar 2018</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<b>Installer Responsibilities</b>					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

*HELICOPTER EXPRESS*